

Work Order ID 135642-2 Split

Thursday, August 13, 2015 1:46:16 PM

135642

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Ship Lot 4

Item ID: D3197-041

Revision ID:

Item Name: Bar

Start Date: 8/13/15

Start Qty: 200

Required Date: 8/13/15

Req'd Qty: 200

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 15-

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3197

Rev B

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks: 29.125" long

0.00

0.00

DAS

20

9-89

15-08-17

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Face ends to length per dwg D31972-Machine D3197-1 as per Folio FA340 and Dwg D31973-Deburr

0.00

0.02

DAS

20

9-89

15-08-18

120

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

DAS

20

9-89

15-08-18

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Item ID: D3197-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 8/13/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/13/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Lathe Conv Conventional Lathe	CONVENTIONAL LATHE Memo Chamfer as per Dwg D3197	0.00 0.00				5	0		DAS 20 9-89 15-08-18
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				5			SL 15-8-19
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				5	0	15-8-20	Doc

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Item ID: D3197-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 8/13/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/13/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M 130746.</i> Memo START TIME: <i>2:45</i> OVEN TEMPERATURE: <i>300</i> FINISH TIME: <i>3:15</i>	0.00 0.00				<i>5</i>	<i>15</i>	<i>8-24</i>	<i>38</i> 9-89
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(5)</i>			DAS 38 9-89 AUG 25 2015
180 *180* Small Fab Small Fab Small Fab	Small Fab Memo Assemble D3197-041 as per Dwg D3197	0.00 0.01				<i>34</i>			DAS 36 9-89 <i>15/09/01</i>

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Item ID: D3197-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 8/13/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/13/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							DAS
190						(3)			38
QC	Memo	0.00							9-89
Quality Control									SEP 01 2015
200	Identify as per dwg & Stock Location: <i>sl 286</i>	0.00							
200									
Packaging	Memo	0.00							27 9-89
Packaging									3X
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									15/9/3 <i>df</i>

SEP 03 2015

SDH 20150103

Picklist Print

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Work Order ID: 135642

135642

Parent Item: D3197-041

D3197-041

Parent Item Name: Bar

Start Date: 8/13/15

Required Date: 8/13/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A New Issue 05-11-08 JLM
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-24		Purchased	No			100	Each	31.0000	2	4		15/08/27	DAS 36 9-89
MS27039-1-24													
Screw													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				3					
				m127432				3					
				ST284				28					
				m127432				28					
D2690-5		Manufactured	No			180	Each	3.0000	2	4		15/08/27	DAS 36 9-89
D2690-5													
Lanyard Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST009				3					
				135073				3					
D3242-1		Manufactured	No			180	Each	0.0000	2	4		15/08/27	DAS 36 9-89
D3242-1													
Tag													
D3489-3-200		Manufactured	No			180	Each	0.0000	2	4		15/08/27	DAS 36 9-89
D3489-3-200													
Pip Pin													
M7075T73R1.000		Purchased	No			180	f	23.4120	2.42	6.05		15/08/27	DAS 20 9-89
M7075T73R1 000													
7075-T73 Rd Bar 1.00													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT018				23.412					
				m127647				23.412					

12.292

Picklist Print

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Work Order ID: 135642

Parent Item: D3197-041

Parent Item Name: Bar

135642

D3197-041

Start Date: 8/13/15

Start Qty: 2.00

Required Date: 8/13/15

Required Qty: 2.00

MS21042L3

Purchased

No

180

Each

1,578.000

2

4

15/08/27 DAS
36
9-89

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001

393

M130922

393

GA

270

M131317

270

ST305

915

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

333

M132930

500

NAS1149D0363J

Purchased

No

180

Each

1,310.000

6

12

15/08/27 DAS
36
9-89

NAS1149D0363.J

Washer

Location

Loc Qty

Loc Code

CA

569

m130799

569

GA

625

m128429

134

m132677

491

ST269

116

m126319

7

m131618

1

m132317

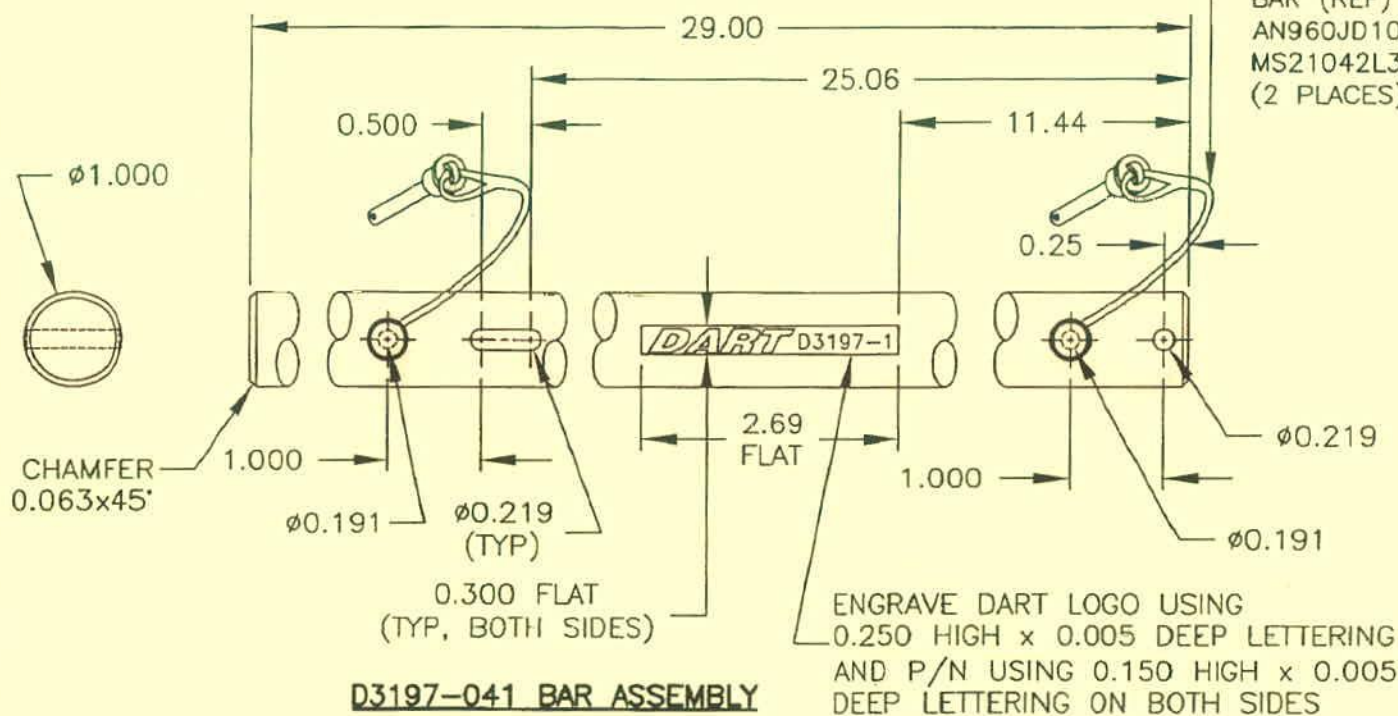
108

4212 24

RELEASED

DART

D3489-3-200 PIP PIN (1)
D3242-1 TAG (1)
MS27039-1-24 BOLT (1)
AN960JD10 WASHER (1)
D2690-5 LANYARD (1)
AN960JD10 WASHER (1)
BAR (REF)
AN960JD10 WASHER (1)
MS21042L3 NUT (1)
(2 PLACES)



D3197-041 BAR ASSEMBLY

D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D. (REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

135612
135612
135612

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.10	TITLE	D3197	REV. B
		BAR		SHEET 1 OF 1
		NEW ISSUE		SCALE 1:1
		CHG PIP PIN; ADD D3242-1 TAG		